

# Work Order ID 58654

May 13, 2010 8:49:26 AM



Page 1

Item ID: D3372-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Cam Lock Shaft

Start Date: 13/05/2010 Start Qty: 5.00

Required Date: 14/05/2010 Req'd Qty: 5.00

Reference: *10.05.13*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw - Plan  
Rev. Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3372

Rev B

100

0.00



Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

Hardinge CNC Lathe Small

Machine D3372-5 as per Folio FA497 and Dwg D3372 Identify as D3372-5 - Deburr

*SA 10/05/13*

*5*

*Ø*

*Pro*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*SA 10/05/13*

*5*

*Ø*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*[Signature]*

*5*

*Ø*

**Dart Aerospace Ltd**

W/O: 58654		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0.05.3	105	Mill slot as per dwg.  perm. chg	AS	10/05/13	5	CR	

Part No: D 3372-5 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location 053

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/13 (5)

10/05/17

ME 10-5-14

# Picklist Print

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Work Order ID: 58654

Parent Item: D3372-5

Parent Item Name: Cam Lock Shaft

Comments: IPP A 05.01.18 New issue KJ/JLM

Start Date: 13/05/2010

Required Date: 14/05/2010

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M303R0.375		Purchased	No			100	f	7.9000	0.075			



303 Round Bar 0.375"



Location

Loc Qty

Loc Code

MAT028

7.9

112041

7.9

2.6A SN 10/05/13

DART AEROSPACE LTD		Work Order: 58654
Description: Cam Lock Shaft		Part Number: 13342-5
Inspection Dwg: 13342 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

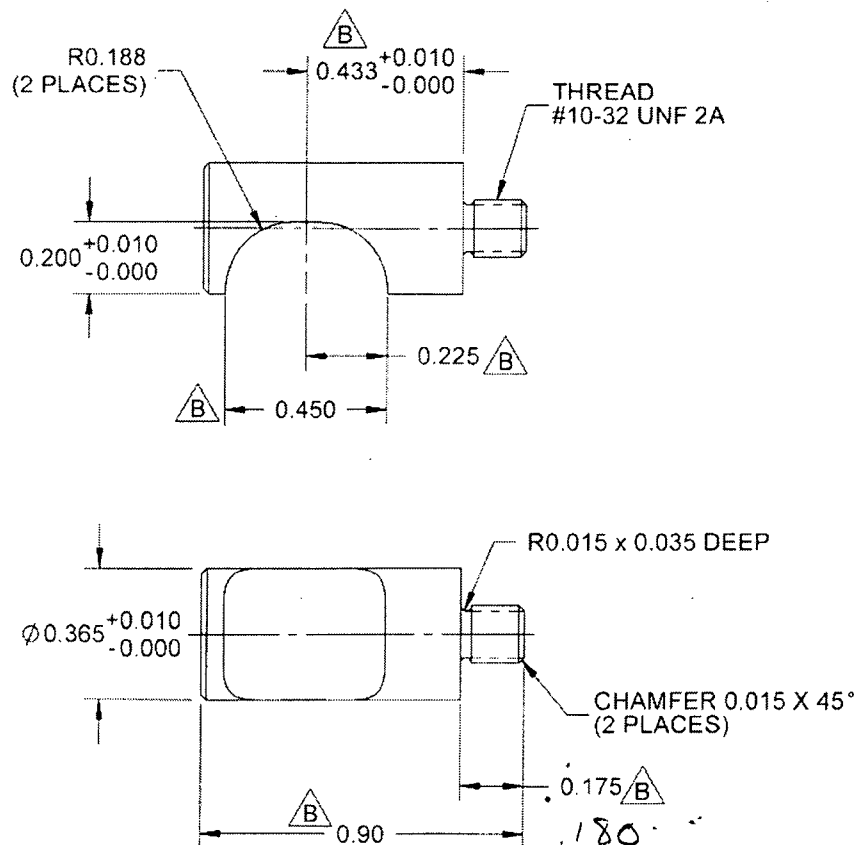
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R.188	$\pm .010$	R.1875	/			
.200	$\pm .010$ $\pm .000$	.203	/			
.450	$\pm .010$	.450	/			
.433	$\pm .010$ $\pm .000$	.438	/			
$\emptyset .365$	$\pm .010$ $\pm .000$	$\emptyset .371$	/			
.90	$\pm .030$	.901	/			
.175	$\pm .010$	.181	/			
Major $\emptyset$	.190-.184	.187	/			
M.O.W.	.212-.214	.213	/			

Measured by: SA	Audited by: [Signature]	Prototype Approval: N/A
Date: 10/05/13	Date: 10-05-13	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 6 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1



### D3372-5 CAM LOCK SHAFT

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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